Work Order ID 88408

88408

August-02-12 8:51:43 AM

Item ID: D4419-1

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Revision ID:

Item Name: Fwd Support Plate

Start Date: 7/27/12 **Start Qty:** 8.00 *8*

Required Date: 8/17/12 **Req'd Qty:** 8.00 *8*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ____ **Date:** 12-08-9 **Tooling:** ____ **Date:** ____

QC: ____ **Date:** ____ **SPC (Y/N):** ____ **Date:** ____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
						8			

Draw Nbr	Revision Nbr
D4419	A

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
100 *100* Waterjet FLOW CNC Waterjet 304.125	**Memo** 1-Cut as per Dwg Dwg Rev: A Prog Rev: A 2-Deburr if necessary	0.00 0.00						IB 12-8-22	
110 *110* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB **Memo**	0.00 0.00						IB 12-8-22	

DQA: ________ Date: ________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ____	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ____	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ____	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	General			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ____
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	____	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	____	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	____	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Work Order ID 88408

August-02-12 8:51:43 AM

88408

Item ID: D4419-1

Revision ID:

Item Name: Fwd Support Plate

Accept *N900040100*

Setup **Start** *NS1*

Stop *NS2*

Start Date: 7/27/12 **Start Qty:** 8.00 *8*

Required Date: 8/17/12 **Req'd Qty:** 8.00 *8*

Cust Item ID:

Customer:

Reference:

Run **Start** *NR1*

Stop *NR2*

Approvals: **Process Plan:** ______ **Date:** ______ **Tooling:** ______ **Date:** ______

QC: ______ **Date:** ______ **SPC (Y/N):** ______ **Date:** ______

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 SmB 12-8-23 0.00	DAS 16 9-89 12/08/23			8			
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: 107 Memo	0.00 0.00		rl		8	8	12/8/23	
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00					MCJ	12/08/23	

MF 12-08-23

DQA: ________ Date: ____________

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______	**DISPOSITION**	**AGAINST DEPARTMENT/PROCESS**			
Part No. ______	Rework ☐	Skid-tube ☐	Crosstube ☐	Water Jet ☐	Engineering ☐
NCR No. ______	Scrap ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coor. ☐	Quality ☐
	Use-as-is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐
	Work Order Update ☐	Large Fab ☐	Composite ☐	Supplier ☐	☐

Root Cause		Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data	☐									
Equip/Tooling	☐									
Operator	☐									
Material	☐									
Setup	☐									
Other	☐									
Process	☐									
Supplier	☐									
Training	☐									
Unapproved	☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped.	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset	______	
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration	______	
☐ Turning Sequence	☐ Finish	☐ Out of Sequence	______	
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

Picklist Print

August-02-12 8:51:43 AM

Work Order ID: **88408**

Parent Item: **D4419-1**

Parent Item Name: Fwd Support Plate

Start Date: 7/27/12 **Required Date:** 8/17/12

Start Qty: 8.00 **Required Qty:** 8.00

Comments: IPP REV:A NEW ISSUE 11-07-11 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA 304/316 0.125 Sheet		Purchased	No				sf	272.6760		**2.9103158**	3	8-8-12	

Location	Loc Qty	Loc Code
MAT020	272.676	
121780	4.976	
122521	267.7	

122521

8

DQA: ______ Date: ______

NCR: Yes / No

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: Date:

Work Order: ______ Part No. ______ NCR No. ______	**DISPOSITION** Rework ☐ Scrap ☐ Use-as-is ☐ Work Order Update ☐	**AGAINST DEPARTMENT/PROCESS** Skid-tube ☐ Crosstube ☐ Water Jet ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coor. ☐ Quality ☐ Thermoforming ☐ Finishing ☐ Rec/Store/Packaging ☐ Other ☐ Large Fab ☐ Composite ☐ Supplier ☐ ☐

Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector
Doc/Data ☐									
Equip/Tooling ☐									
Operator ☐									
Material ☐									
Setup ☐									
Other ☐									
Process ☐									
Supplier ☐									
Training ☐									
Unapproved ☐									

FAULT CATEGORY

Landing Gear	**General**			
☐ Bending	☐ Bend	☐ Grain	☐ Ovalized	☐ Pressure/Forced
☐ Centre Not Concentric to O/S	☐ BOM/Route	☐ Hardware	☐ Over/Under tolerance	☐ Temperature/Cure
☐ Cracks	☐ Broken/Damaged	☐ Inspection Incomplete	☐ Part Incorrect	☐ Weld
☐ Crushed/Crimped	☐ Burrs	☐ Instructions Incomplete/Unclear	☐ Part Lost/Missing	☐ Wrong Stock Pulled
☐ Cuffs	☐ Contamination	☐ Maintenance	☐ Part Moved	
☐ Heat Treat	☐ Countersink	☐ Mislabeled	☐ Positioned Wrong	
☐ Inspection Strip in Tube	☐ Cut Too Short	☐ Misread	☐ Power Loss/Surge	☐ Other ______
☐ Ripples in Bend	☐ Drill Holes	☐ Offset		______
☐ Torque Waves in Extrusion	☐ Drawing	☐ Out of Calibration		______
☐ Turning Sequence	☐ Finish	☐ Out of Sequence		______
☐ Wave/Twist in Tube	☐ Folio	☐ Outside Dimensions		

DART AEROSPACE LTD	Work Order:	88408
Description: Fwd Support Plate	Part Number:	D4419-1
Inspection Dwg: D4419 Rev: A		

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.129	+0.005/-0.001	.131	[illegible]		V [illegible]	
Ø0.191	+0.005/-0.001	.192	[illegible]		V	
Ø0.250	+0.005/-0.001	.251	[illegible]		V	
Ø0.257	+0.006/-0.001	.257	[illegible]		V	
5.70	+/-0.030	5.703	[illegible]		V	
4.40	+/-0.030	4.410	[illegible]		V	
0.55	+/-0.030	.552	[illegible]		V	
2.80	+/-0.030	2.798	[illegible]		V	
1.30	+/-0.030	1.294	[illegible]		V	
4.35	+/-0.030	4.358	[illegible]		V	
5.71	+/-0.030	5.706	[illegible]		V	
0.450	+/-0.010	.450	[illegible]		V	
0.80	+/-0.030	.806	[illegible]		V	
1.20	+/-0.030	1.209	[illegible]		V	
1.10	+/-0.030	1.088	[illegible]		V	
3.25	+/-0.030	3.25	[illegible]		V	
4.10	+/-0.030	4.104	[illegible]		V	
1.20	+/-0.030	1.209	[illegible]		V	
7.32	+/-0.030	7.32	[illegible]		V	
8.78	+/-0.030	8.794	[illegible]		PROJ[illegible]	
0.65	+/-0.030	.652	[illegible]		V	
0.60	+/-0.030	.604	[illegible]		V	
1.750	+/-0.010	1.751	[illegible]		V	
0.303	+/-0.010	.306	[illegible]		V	
1.500	+/-0.010	1.502	[illegible]		V	
2.300	+/-0.010	2.298	[illegible]		V	
3.900	+/-0.010	3.901	[illegible]		V	
0.34	+/-0.030	.338	[illegible]		V	
0.750	+/-0.010	.752	[illegible]		V	
1.37	+/-0.030	1.371	[illegible]		V	
0.440	+/-0.010	.442	[illegible]		V	
0.760	+/-0.010	.760	[illegible]		V	
0.375	+/-0.010	.376			V	

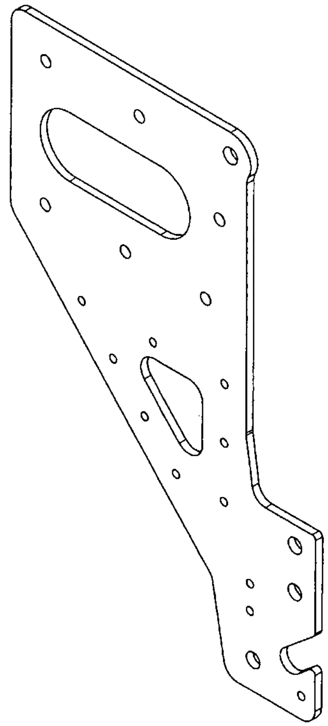
DART AEROSPACE LTD	Work Order:	88408
Description: Fwd Support Plate	**Part Number:**	**D4419-1**
Inspection Dwg: D4419 **Rev:** A		**Page 2 of 2**

FIRST ARTICLE INSPECTION CHECKLIST

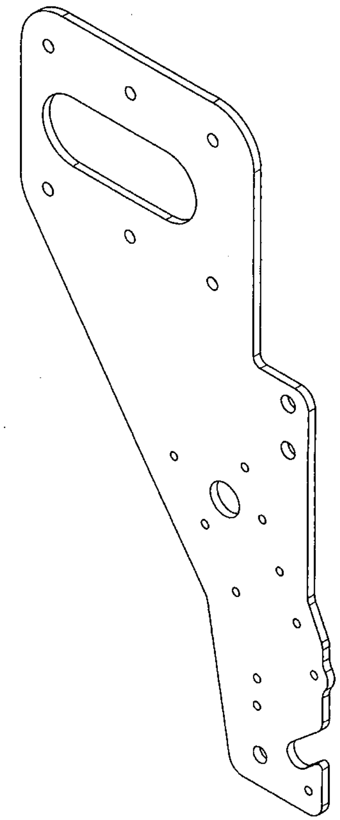
Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.250	+/-0.010	.250	2		V BOL	
0.900	+/-0.010	.898	\		V	
0.063	+/-0.010	.063	2		V	
0.125	+/-0.010	.125	1		V	
1.330	+/-0.010	1.333	2		V	
0.950	+/-0.010	.953	2		V	
0.866	+/-0.010	.865	2		V	
0.40	+/-0.030	.403	2		V	
0.125	+/-0.010	.118	2		V	

Measured by:	B	Audited by:	Smb DAS	Preliminary Approval:	
Date:	12-8-22	Date:	12-8-23 16	17/08/23 Date:	

Rev	Date	Change	Revised by	Approved
A	11.08.22	New Issue	KJ	



D4419-1 FWD SUPPORT PLATE



D4419-3 AFT SUPPORT PLATE

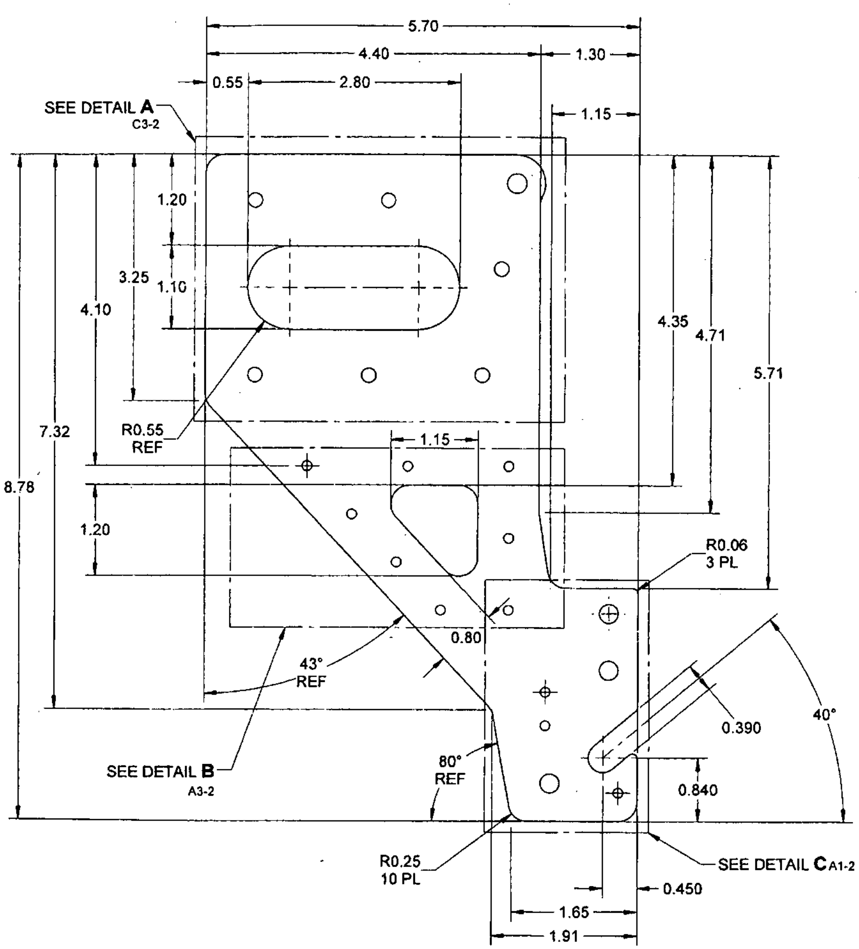
88408
M1208-9

RELEASED
2011-07-28

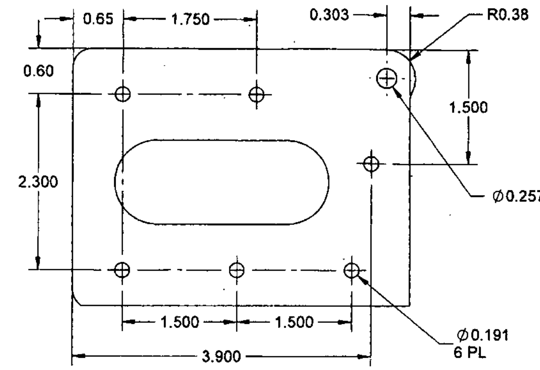
NOTES:
1) MATERIAL: 303/304/316 STAINLESS STEEL SHEET ANNEALED 2B, 0.125 THK
PER MIL-S-5059 OR AMS 5513/5524 OR ASTM A240 OR ASME SA240
REF DART SPEC M304S11GA OR M303S11GA
2) FINISH: NONE
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: NONE
7) WEIGHT -1: 0.88 lbs
-3: 1.10 lbs

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	AJS	11.07.06

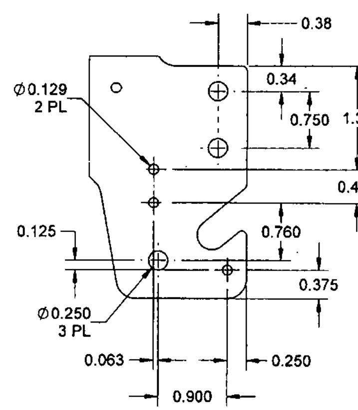
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DRAWN	AJS	
CHECKED	[signature]	DRAWING NO. D4419 REV. A SHEET 1 OF 3
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE BASKET SUPPORT PLATES SCALE NTS
DE APPR.	[signature]	
DATE	11.07.06	



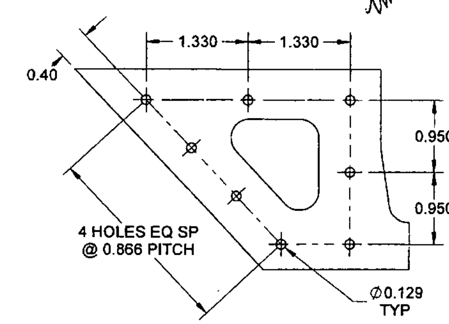
D4419-1 FWD SUPPORT PLATE



DETAIL A D8-2



DETAIL B B7-2

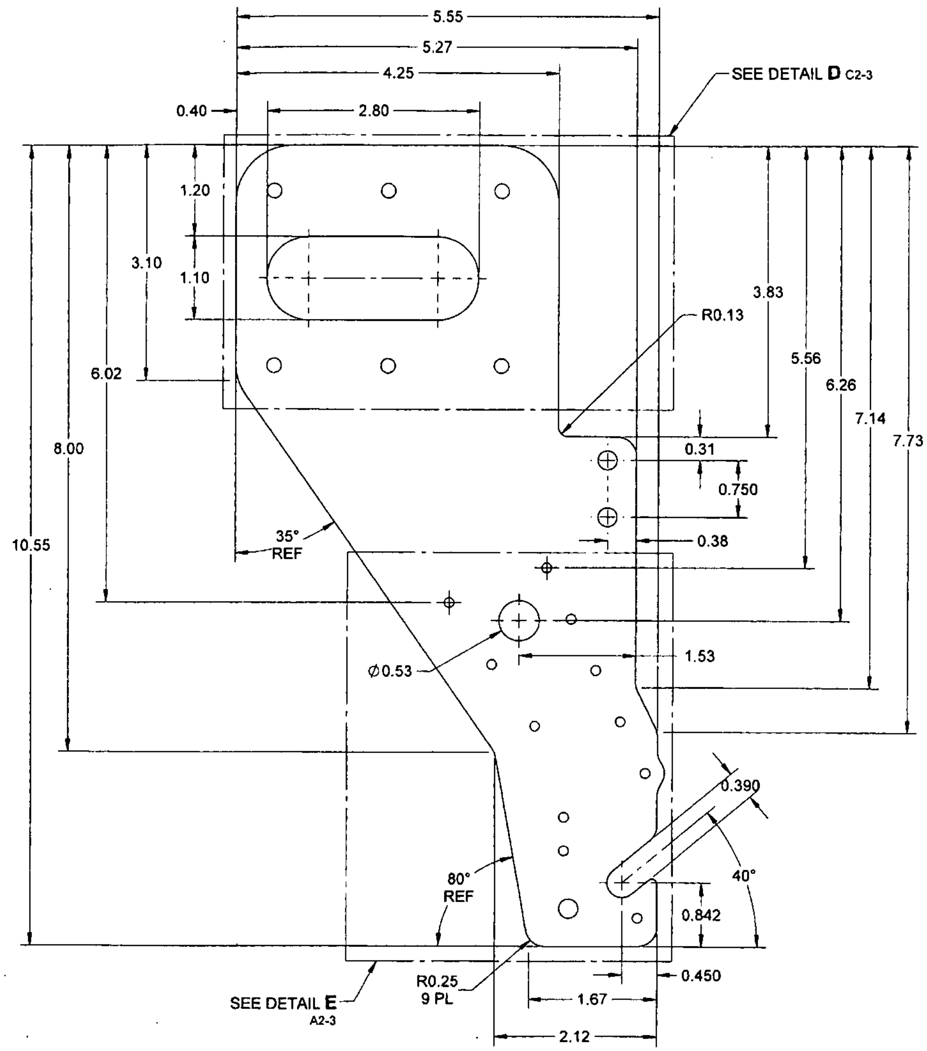


DETAIL C A4-2

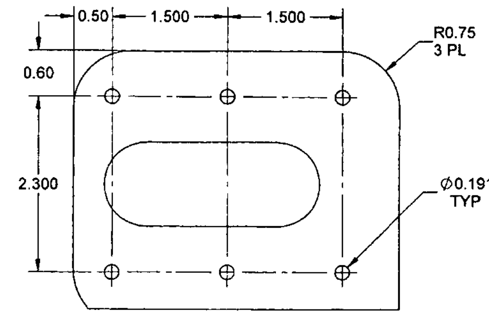
RELEASED 2011-07-28

8 8408

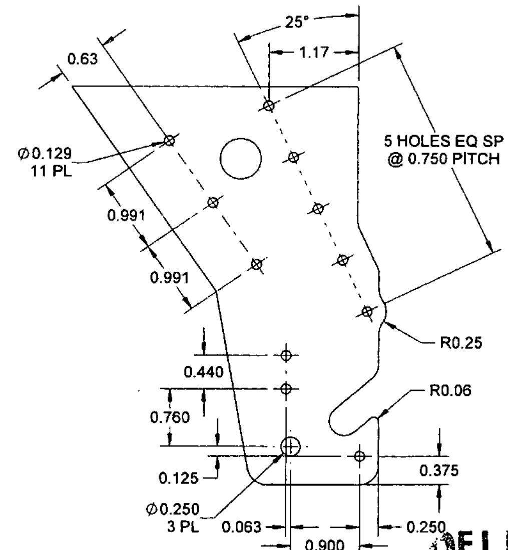
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED	[signature]	DRAWING NO. D4419 — REV. A — SHEET 2 OF 3
MFG. APPR.	[signature]	
APPROVED	[signature]	TITLE: BASKET SUPPORT PLATES — SCALE NTS
DE APPR.	[signature]	
DATE	11.07.06	



D4419-3 AFT SUPPORT PLATE



DETAIL D D5-3



DETAIL E A7-3

DESIGN	AJS	**DART AEROSPACE LTD** HAWKESBURY, ONTARIO, CANADA
DRAWN	AJS	
CHECKED		DRAWING NO. D4419 — REV. A — SHEET 3 OF 3
MFG. APPR.		
APPROVED		TITLE BASKET SUPPORT PLATES — SCALE NTS
DE APPR.		
DATE	11.07.06	